

# Work Order ID 80157

February-13-12 8:04:48 AM

**\*80157\***

Page 1

Item ID: DSK078

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: D2893-1 TURNING DETAIL

Start Date: 13/02/2012 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 27/02/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: M.L.J.

Date: 12/02/13

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

DSK078

Rev A

100

0.00

**\*100\***

Doosan

Doosan Lathe

Memo

Turn blank as per Folio FA081  
(4TH AXIS PLUG DT8492)

0.00

20 12.3.23

20

φ

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Quality Control

Memo

0.00

20 12.3.23

20

φ

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Quality Control

Memo

0.00

B.A 12/03/26

20

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 80157

**\*80157\***

Page 2

February-13-12 8:04:48 AM

Item ID: DSK078 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: D2893-1 TURNING DETAIL  
 Start Date: 13/02/2012 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 27/02/2012 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
<b>*130*</b>						20	0		
Packaging	Memo	0.00		B.A	12/03/26				
Packaging	Identify and Stock in Kanban Location: <u>CNC</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

12/3/26 *[Signature]*

12-03-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

February-13-12 8:04:55 AM

Page 1

Work Order ID: 80157

\*80157\*

Parent Item: DSK078

\*DSK078\*

Parent Item Name: D2893-1 TURNING DETAIL

Start Date: 13/02/2012

Required Date: 27/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6104-005		Manufactured	No				Each	0.0000		10			
*D6104-005*									**	10			
Round Billet, 17-4													

80933

80114

\*\*

12/3/23

6

14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	80157
Description: Turning Detail for D2893-1		Part Number:	DSK078
Inspection Dwg: DSK078 Rev: A		Page 1 of 1	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712		2.712	2.712	2.712	2.712	2.712
B	4.946	4.966		4.960	4.962	4.962	4.962	4.960
C	3.064	3.084		3.074	3.075	3.077	3.075	3.074
D	0.718	0.738		.730	.730	.730	.730	.730
E	0.090	0.110		.101	.101	.100	.100	.100
F	2.934	2.954		2.944	2.944	2.944	2.944	2.944
G	2.166	2.186		2.176	2.176	2.176	2.176	2.176
H	3.890	3.910		3.901	3.900	3.901	3.901	3.901
I	0.914	0.934		.928	.928	.928	.928	.928
J	0.022	0.042		.031	.031	.031	.031	.031
K	0.109	0.129		.116	.116	.116	.116	.116
L								
M								
N								
O								
P								

Measured by:	SA/29	Date:	12/3/23
Audited by:	BA	Date:	12/03/26
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	80157
<b>Description:</b> Turning Detail for D2893-1		<b>Part Number:</b>	DSK078
<b>Inspection Dwg:</b> DSK078		<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1/16	1/17	1/18	1/19	1/20
Lathe Section								
A	2.707	2.712		2.710	2.710	2.710	2.710	2.710
B	4.946	4.966		4.960	4.960	4.960	4.960	4.960
C	3.064	3.084		3.075	3.075	3.075	3.075	3.075
D	0.718	0.738		.730	.730	.730	.730	.730
E	0.090	0.110		.100	.101	.100	.101	.100
F	2.934	2.954		2.945	2.944	2.945	2.945	2.945
G	2.166	2.186		2.177	2.177	2.177	2.177	2.177
H	3.890	3.910		3.900	3.901	3.901	3.901	3.901
I	0.914	0.934		.928	.928	.928	.928	.928
J	0.022	0.042		.031	.031	.031	.031	.031
K	0.109	0.129						
L								
M								
N								
O								
P								

Measured by: SA/24 Date: 12.3.23

Audited by: BA Date: 12/03/26

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order:	80157
Description: Turning Detail for D2893-1		Part Number:	DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	77	88	69	610
Lathe Section								
A	2.707	2.712		2.710	2.710	2.710	2.710	2.710
B	4.946	4.966		4.960	4.960	4.960	4.960	4.960
C	3.064	3.084		3.075	3.074	3.074	3.074	3.075
D	0.718	0.738		.730	.730	.730	.730	.730
E	0.090	0.110		.101	.100	.101	.100	.107
F	2.934	2.954		2.944	2.944	2.944	2.945	2.945
G	2.166	2.186		2.176	2.177	2.177	2.178	2.177
H	3.890	3.910		3.900	3.901	3.899	3.901	3.901
I	0.914	0.934		.928	.928	.928	.928	.928
J	0.022	0.042		-.031	-.031	-.031	-.031	-.031
K	0.109	0.129						
L								
M								
N								
O								
P								

Measured by:	<i>[Signature]</i>	Date:	12.7.23
Audited by:	B.A	Date:	12/03/26
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	80157
Description: Turning Detail for D2893-1		Part Number:	DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11	12	13	14	15
Lathe Section								
A	2.707	2.712		2.710	2.710	2.710	2.710	2.710
B	4.946	4.966		4.960	4.960	4.960	4.960	4.960
C	3.064	3.084		3.074	3.075	3.075	3.075	3.074
D	0.718	0.738		.730	.730	.730	.730	.730
E	0.090	0.110		.100	.100	.100	.100	.100
F	2.934	2.954		2.943	2.943	2.945	2.945	2.944
G	2.166	2.186		2.177	2.176	2.177	2.179	2.176
H	3.890	3.910		3.901	3.901	3.900	3.900	3.901
I	0.914	0.934		.928	.928	.928	.928	.928
J	0.022	0.042		.031	.031	.031	.031	.031
K	0.109	0.129						
L								
M								
N								
O								
P								

Measured by: SA/124 Date: 12.3.23

Audited by: BA Date: 12/03/26

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	



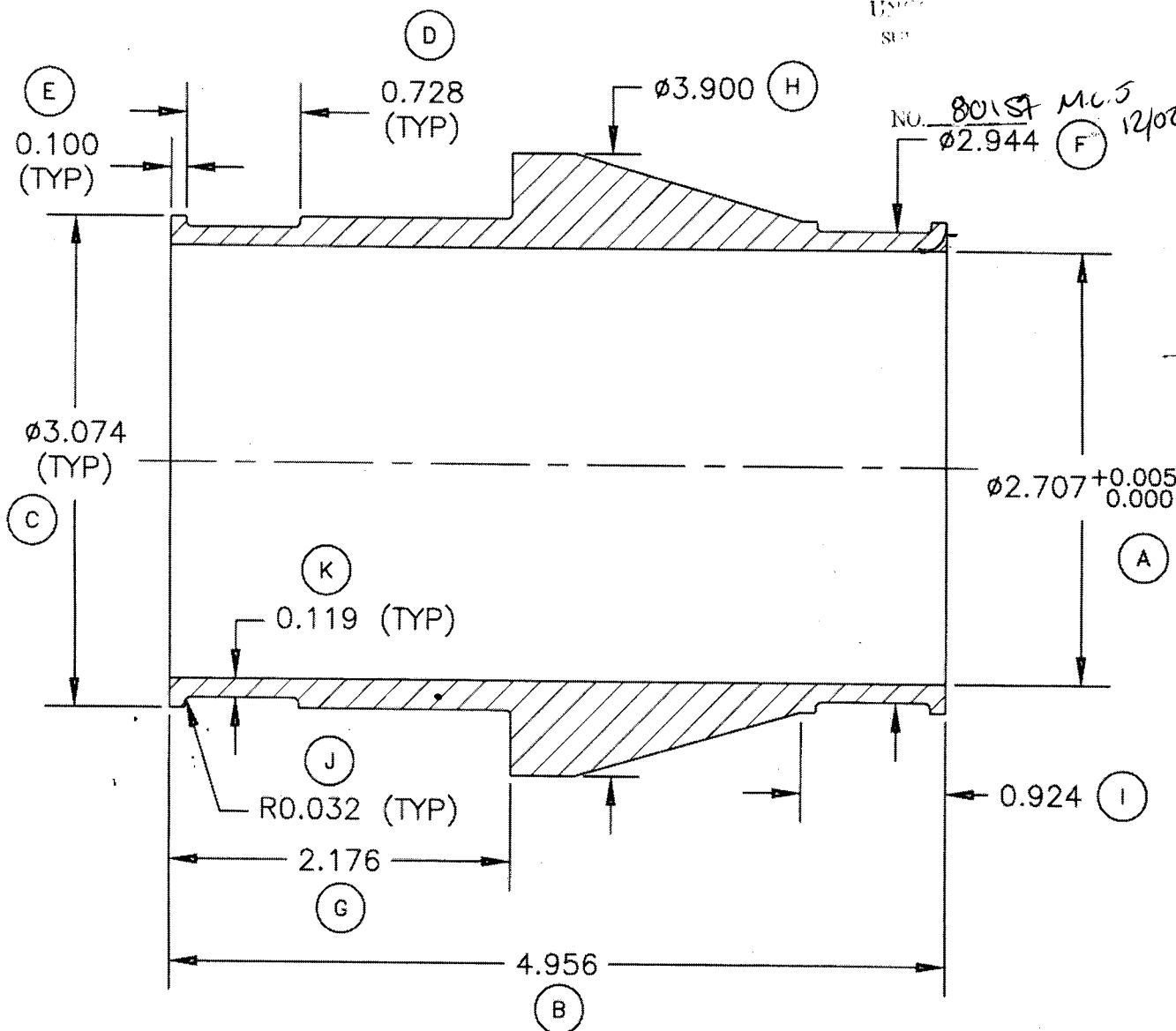
DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. DSK 078	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2893-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED  
#03.07.01

SHOP

UNCL  
SEP

NO. 80157 MC.5 12/02/13  
Ø2.944 (F)



D2893-1 TURNING DETAIL

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries